



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9086	REV. A SHEET 1 OF 1
DATE 97.10.15		TITLE 205 SKIDTUBE STEP CHANGE	SCALE 1:10
A	97.10.15	NEW ISSUE	

DART SERVICE INSTRUCTION

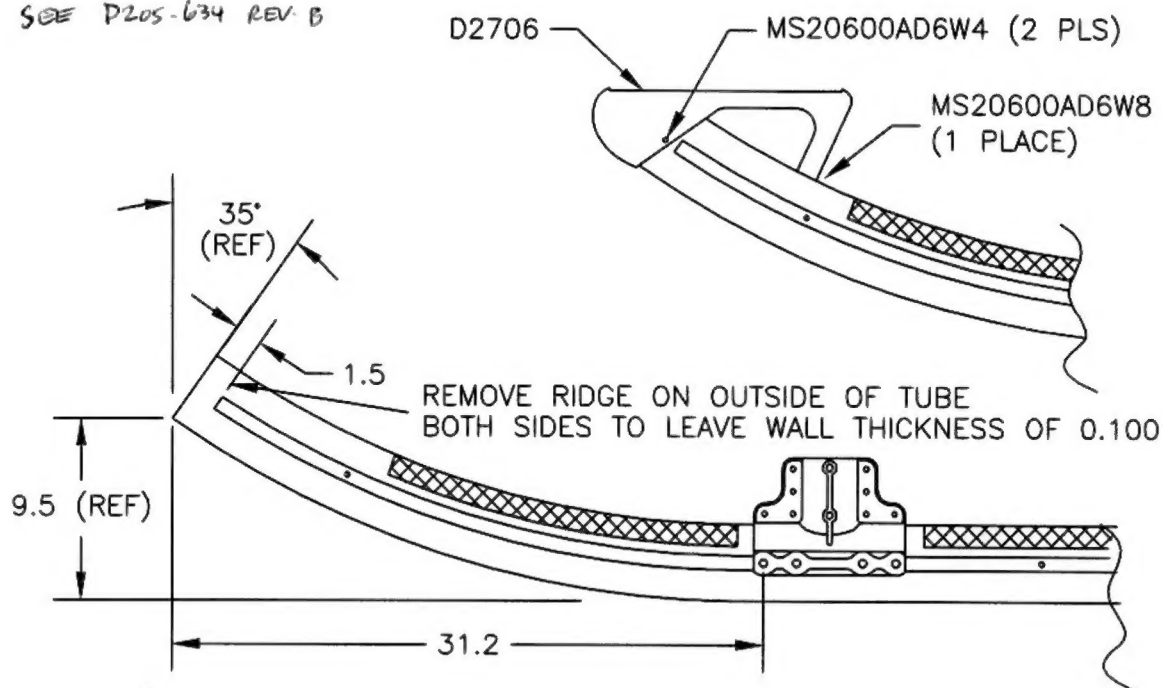
TO AMEND INSTALLATION DRAWINGS D205-634 REV A

SUPERCEDED BY

98/09/17 DS

SEE D205-634 REV B

STA: SH96-88
STC: SR00563NY



FOR EARLY SKIDTUBES IN SERVICE WITH FLAT STEP

1. CUT TUBE TO DIMENSIONS SHOWN AND DE-BURR
2. REMOVE RIDGE ON OUTSIDE OF TUBE
3. LOCATE D2706 STEP
4. TRANSFER DRILL $\phi 0.191$ TO SKIDTUBE (3 PLACES) AND REMOVE SWarf
5. INSTALL MS20600AD6W4 (OR CR9163-6-4) RIVETS ON SIDES (2 PLACES)
6. INSTALL MS20600AD6W8 (OR CR9163-6-8) RIVETS ON TOP (1 PLACE)
7. SEAL EDGE OF D2706 STEP WITH SIKAFLEX-241 (OR EQUIVALENT) SEALANT PER MANUFACTURER'S SPECIFICATION

REVISED WEIGHT AND BALANCE: (WITH D2706 STEP INSTALLED)

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D205-634-011	39.7 LB EA.	112 IN	4446.4 IN-LB
	18.0 KG EA.	2.84 M	51.1 M-KG